

Date: Monday, 6/12/2006 3:37:05 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FLOOR PROTECTOR FWD LH
 Job Number : 27508
 Estimate Number : 11227
 P.O. Number : N/A Part Number : D32811
 This Issue : 6/12/2006 S.O. No. : N/A Drawing Number : D3281 REV B
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : PURCHASED PARTS Drawing Revision : B
 Previous Run : 26353 Material : N/A
 Written By : *See Comment Below* Due Date : 6/30/2006 Qty: 20 Um: Each
 Checked & Approved By : *06.06.13*
 Comment : Est Rev: A 04.07.01 New issue KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: 1493
 Description: Floor Protector Fwd, LH
 Possible Supplier: Delastek
 Certificate of Conformity is required

C206105/06 (20)

2.0 D32811P Floor Protector, Fwd LH



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)
 Floor Protector Fwd, LH

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage
 Ensure certificate of conformity is attached

6/7/12 (20)
6/7/10 (20)

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3280 and certification attached. Visual inspection check for void spots and pins.

6/7/12 (20)

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
 Location:

6/7/18 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 06/07/24

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 6/12/2006 3:37:05 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR PROCTOR FWD LH

Job Number: 27508

Part Number: D32811

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06.07.19

Job Completion



U 06.07.19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

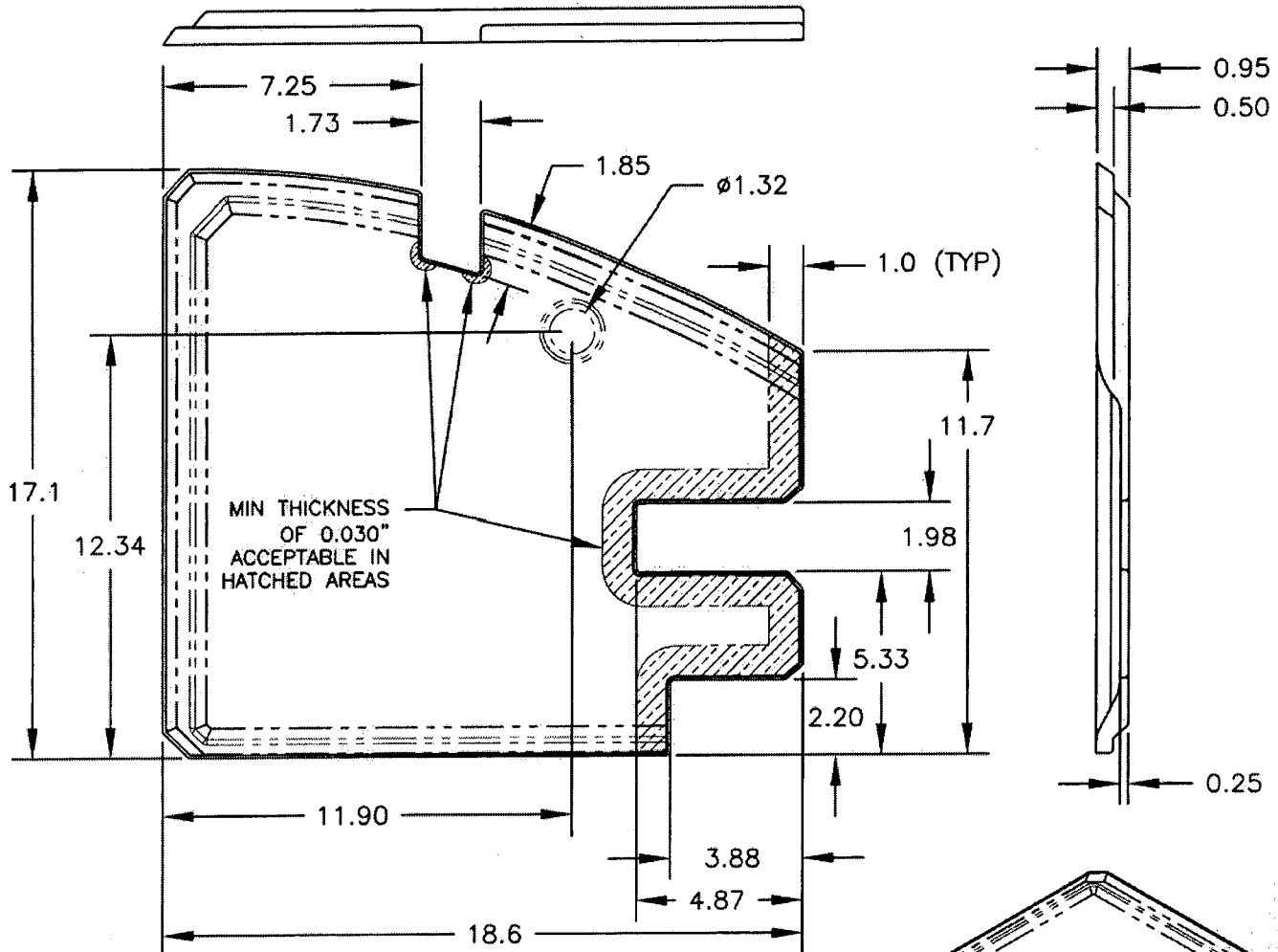
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3281	REV. B SHEET 1 OF 3
DATE 05.11.25		TITLE FLOOR PROTECTOR	SCALE 1:5
A	04.05.03	NEW ISSUE	
B	05.11.25	NOW LEXAN; DIMS AS MANUFACTURED	

**RELEASED**
05.12.01**D3281-1 FLOOR PROTECTOR, FWD LH**

- 1) THERMOFORM D3281-1 USING MOLD D3281-1T1, TRIM USING D3281-1T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

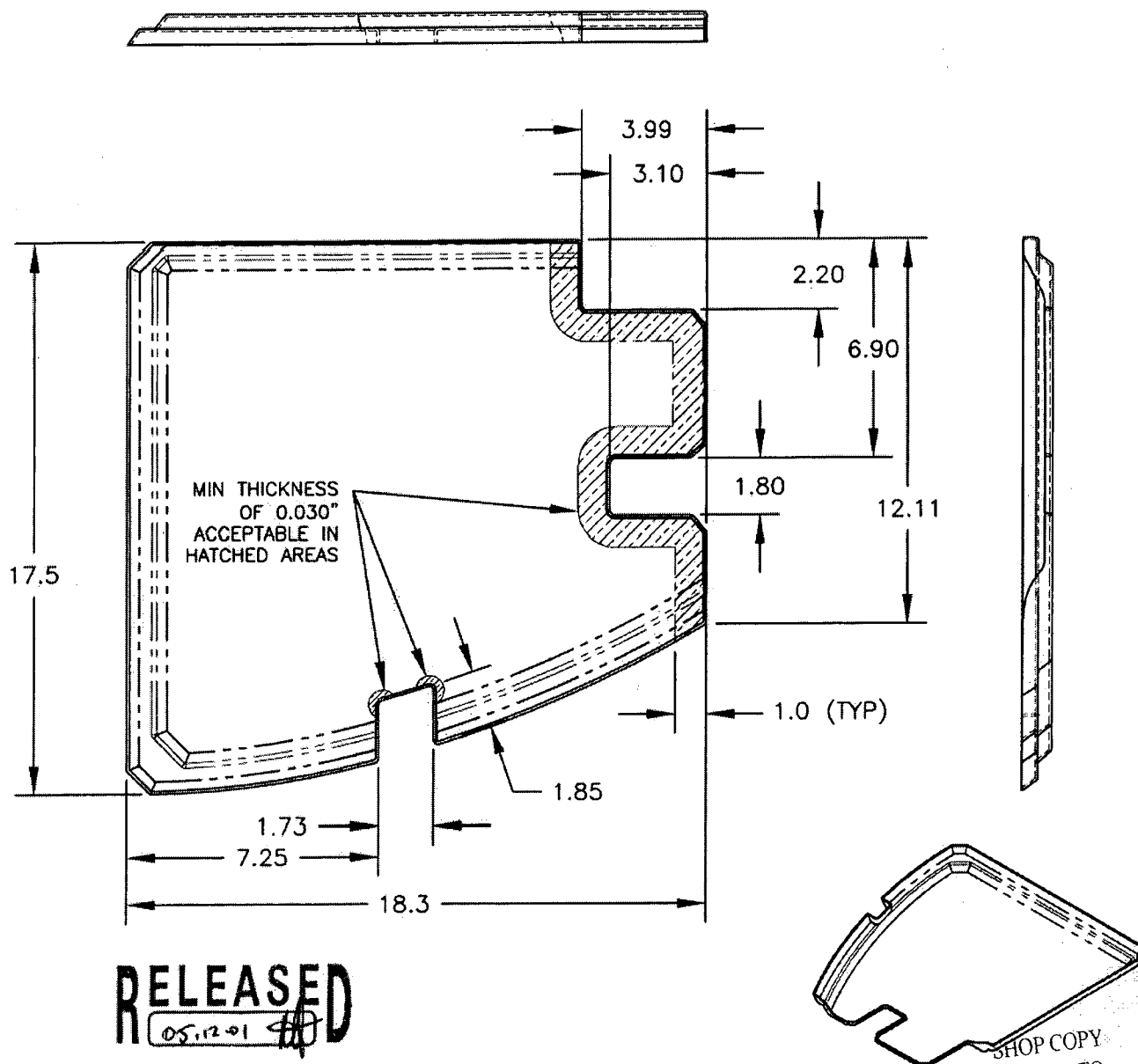
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WITHOUT NOTICE
WORK ORDER
NO. 27508

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3281	REV. B SHEET 2 OF 3
DATE 05.11.25		TITLE FLOOR PROTECTOR	SCALE 1:5

**D3281-2 FLOOR PROTECTOR, FWD RH**

- 1) THERMOFORM D3281-2 USING MOLD D3281-2T1, TRIM USING D3281-2T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

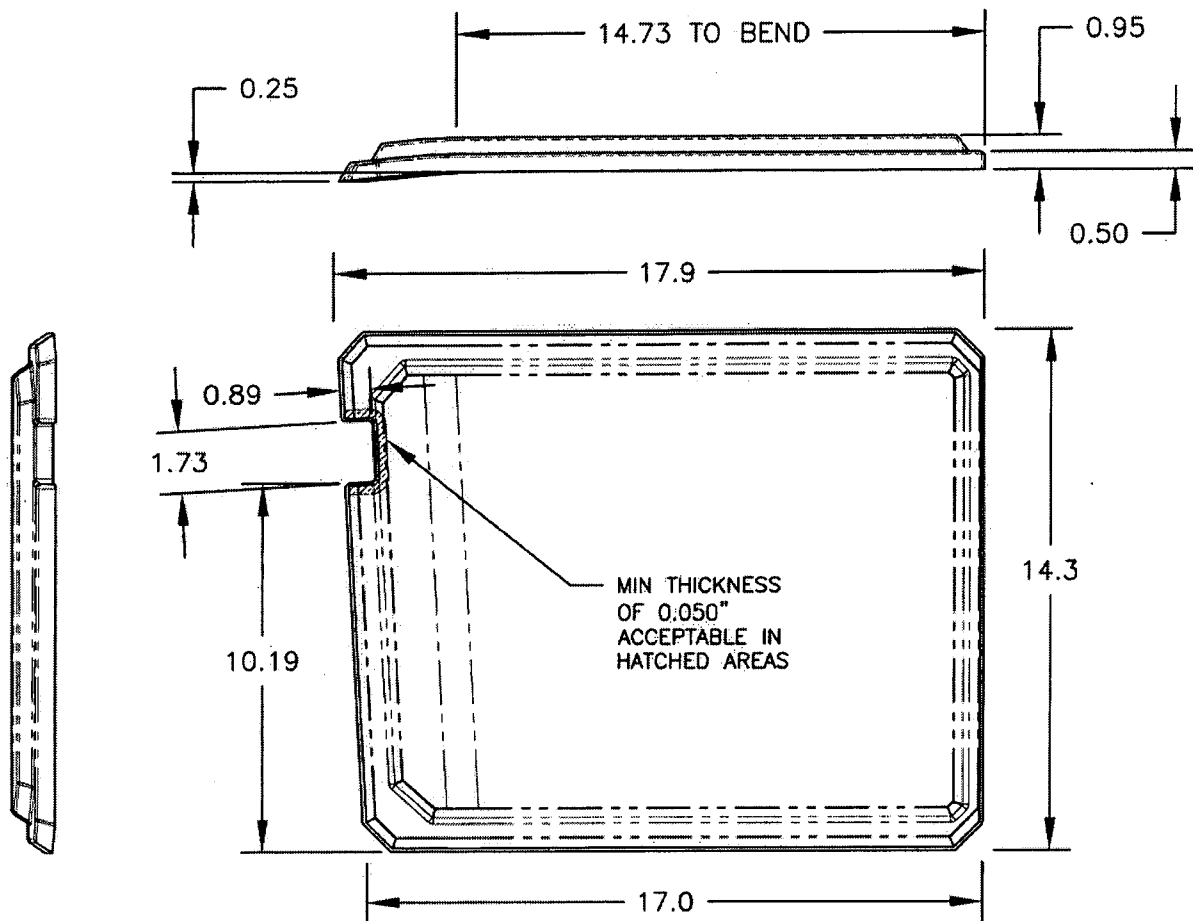
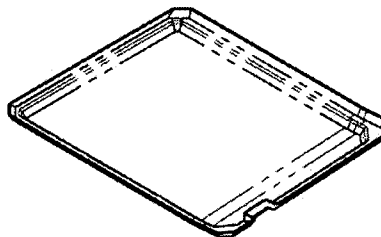
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3281	REV. B SHEET 3 OF 3
DATE 05.11.25		TITLE FLOOR PROTECTOR	SCALE 1:5

**RELEASED**
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WITHOUT NOTICE
WORK ORDER
NO. **27508****D3281-3 FLOOR PROTECTOR. AFT LH (SHOWN)****D3281-4 FLOOR PROTECTOR. AFT RH (OPPOSITE)**

- 1) THERMOFORM D3281-3 USING MOLD D3281-3T1, TRIM USING D3281-3T2
THERMOFORM D3281-4 USING MOLD D3281-4T1, TRIM USING D3281-4T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

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DELASTEK COMPOSITES INC.
2699, Sième Avenue
Local 14, PORTE -A-
Grand-Mère, Québec G9T 5K7
Can **Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	10737
Customer #	DART

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Ship to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Telephone: 613-632-3336

Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
PURO COLLECT		Origin		Net30 days		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by	Your PO #	GST/PST #		
11/07/06	15/06/06	4716	C. Lavoie	PO00001493			
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
20	0	20	DKC134-0044	Floor Protect Part 1 N° D3281-1 (F6006) Selon dessin D3181 Rev.: B JOB: 36892 QTÉ: 20 U de M : Each			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☐ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:

Quality department AQ-357

Cofc.
Dwa #
collected
to
follow

Feuille de Procédé

Client : DART Dart Aerospace Ltd.
Numéro Job : 36892
Numéro Soumission : 2383
Numéro B.A. :
Cette fois : 2006-06-22 No. B.V. :
Prsht Rev. : NC
Prem. fois : - - Type :
Job précédente : 34173

Nom Dessin : FLOOR PROTECTOR
Numéro Article : DKC134-0044
Numéro Dessin : D3281
Projet Numéro : DKC134
Révision dessin : B
Matériel : F6006
Date Dûe : 2006-06-29

Qté: 20 Udm: UNITE

Écrit par :
Vérifié & Approuvé par :
Commentaires : N° de pièce: D3281-1



Process Sheet Rév.: 00 Création du premier

Produit additionnel

Numéro Job:



Séq.: Machine ou Opération:

Description :

1.0 APL0016

Lexan F6006 Noir N° 700 48" x 96" x .125" Thk.

Commentair Qty.: 0.167 UNITE(s)/Unit Total :
Lexan F6006 Noir N° 700 48" x 96" x .125"

APL0016



1-5327-1

Lexan F6006 Noir N° 700 48" x 96" x .125" Thk.

N° de Lot:

Bon achat: 5327

2.0 SÉCHAGE/ ANEAL

SECHAGE / ANEALING



Commentair Setup: 0.00Hrs/ Run: 2.0000Min Total Run : 0.6667Hrs
SÉCHAGE DU MATÉRIEL

Sécher le matériel dans le four à 250° F pendant 6 heures.

Inscrire sur la charte de température le numéro de Job du matériel au séchage.

de cuisson: 5140

3.0 PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 3.0000Hrs Total Run : 60.0000Hrs
TAILLAGE DU MATÉRIEL

Faire le taillage du matériel selon les dimensions suivantes:

24" x 26" x .125" Thk.



1 serg.

Quantité: 20 Date: 4-7-06 Sceau:

Quantité: Date: Sceau:

Feuille de Procédé

Cliant: DART Dart Aerospace Ltd.
 Numéro Job: 36892

Nom Dessin: FLOOR PROTECTOR
 Numéro Article: DKC134-0044

Numéro Job:



Séq.: Machine ou Opération: Description :

4.0 THERMOFORMAGE2 THERMOFORMAGE DES PIÈCE DART



Commentair Setup: 0.50Hrs/ Run: 10.0000Min Total Run : 3.3333Hrs
 THERMOFORMAGE DES PIECES

Faire le thermoformage du " Floor Protector " N° D3281-1 à l'aide du moule N° D3281-1T1 sur le
 thermoformeur 4' x 8'.

Autocontrôle du lot de pièce thermoformées.



F.O: 4/11/06

Quantité: 20 Date: 4-7-06 Sceau:

Quantité: Date: Sceau:

5.0 TRIMAGE 3 TRIMAGE COMPOSITES DART



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 3.3333Hrs
 TRIMAGE PLASTIQUE DART

Faire le trimage du " Floor Protector " N° D3281-1 à l'aide du gabarit de trimage N° D3281-1T2.

Faire l'ébavurage des pièces.

Autocontrôle du lot de pièce trimées.

Quantité: 20 Date: 10-7-06 Sceau: 2/2

Quantité: Date: Sceau:

6.0 INSPECTION 3 INSPECTION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 1.6667Hrs
 INSPECTION PIÈCE DART

Faire l'inspection finale des pièces selon le dessin.

Quantité: 20 Date: 10-07-06 Sceau:



7.0 IDENTIFICATION4 IDENTIFICATION PIÈCES DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 1.6667Hrs
 IDENTIFICATION PIÈCES DART

Faire l'identification des pièces à l'aide des informations suivantes:

Client: DART Dart Aerospace Ltd.
Numéro Job: 36892Nom Dessin: FLOOR PROTECTOR
Numéro Article: DKC134-0044

Numéro Job:



Séq.:

Machine ou Opération:

Description :

N° de pièce: D3281-1

N° de Job: _____

Date de fabrication: _____

Sceau d'inspection:

Quantité: 20 Date: 10-07-06 Sceau: 

Quantité: _____ Date: _____ Sceau: _____

8.0

EMBALLAGE

EMBALLAGE ET ENTREPOSAGE



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 1.6667Hrs

EMBALLAGE ET ENTREPOSAGE

Emballer les pièces individuellement dans un sac en plastique et ensuite mettre dans une boîte en carton
identifiée comme suit:

N° de pièce: D3281-1

Date de fabrication: _____

N° de job: _____

Quantité: 20 Date: 11/7/06 Sceau: 

Quantité: _____ Date: _____ Sceau: _____